

Date: Thursday, 9/14/2006 4:32:39 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, INBOARD, LS, 206
 Job Number : 28603
 Estimate Number : 10820
 P.O. Number : N/A Part Number : D26661
 This Issue : 9/14/2006 S.O. No. : N/A Drawing Number : D2666 REV. C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 28405 Material : N/A
 Due Date : 9/30/2006 Qty: 8 Um: Each
 Written By :
 Checked & Approved By : 060914
 Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
 7075-T7351 2X6X6.25
 Issue material from stock:
 Cut Size 2.0 x 6.25 X 6.0
 Grain Along Long 6.0 Length

Batch No: B25344

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Program batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Fixturing Inspection last completed on 06/09/22 by SL
 3-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
 6-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
 8-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
 9- Deburr

J.L 06/09/22

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

J.L 06/09/22

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06/09/22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ED Date: 04/20/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 4:32:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 28603

Part Number: D26661

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/09/26 x 8

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m

06-09-27

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

4/

06/09/28 x 8

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC 06 09 28

(x8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57471

06/09/28 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/07

Job Completion



06/10/07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 28603
Description: 206 Saddle, Inboard, Left side	Part Number: D2666-1
Inspection Dwg: D2666 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.124	.124	.124	.124		
B	0.100	0.140		.121	.122	.122	.122		
C	2.470	2.510		2.495	2.495	2.495	2.495		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.221	.221	.221	.222		
F	1.313	1.343		1.322	1.329	1.328	1.328		
G	0.240	0.260		.242	.251	.250	.249		
H	0.615	0.685		.675	.675	.675	.675		
I	1.125	1.145		1.134	1.134	1.134	1.133		
J	0.990	1.010		1.001	1.001	1.000	1.001		
K	0.235	0.240		.237	.238	.237	.237		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.112	.113	.112	.112		
N	1.565	1.585	DT 8888	✓	✓	✓	✓		
O	5.990	6.010		6.000	6.001	6.001	6.000		
P	1.245	1.255		1.250	1.250	1.249	1.250		
Q	2.495	2.505		2.500	2.499	2.500	2.500		
R	0.490	0.510		.501	.500	.498	.500		
S	0.313	0.318	DT8686	.314	.314	.314	.314		
T	2.495	2.505		2.500	2.499	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.313	0.318	DT8686	.314	.314	.314	.314		
W	0.540	0.560		.550	.550	.551	.550		
X	1.674	1.684		1.679	1.678	1.679	1.679		
Y	0.257	0.262	DT8683	.258	.258	.258	.258		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	06/09/22

Audited by:	Er
Date:	06/09/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	28603
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.124	.124	.124	.124		
B	0.100	0.140		.122	.123	.122	.122		
C	2.470	2.510		2.493	2.493	2.493	2.493		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.222	.224	.223	.223		
F	1.313	1.343		1.328	1.328	1.328	1.328		
G	0.240	0.260		.250	.251	.251	.251		
H	0.615	0.685		.675	.675	.675	.675		
I	1.125	1.145		1.133	1.133	1.133	1.133		
J	0.990	1.010		1.001	1.001	1.001	1.001		
K	0.235	0.240		.236	.236	.236	.237		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.111	.112	.111	.112		
N	1.565	1.585	DT 8888						
O	5.990	6.010		6.001	6.001	6.000	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.499	.500	.499	.499		
S	0.313	0.318	DT8686	.314	.314	.314	.314		
T	2.495	2.505		2.498	2.498	2.498	2.498		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.313	0.318	DT8686	.314	.314	.314	.314		
W	0.540	0.560		.550	.549	.550	.549		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262	DT8683	.258	.258	.258	.258		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

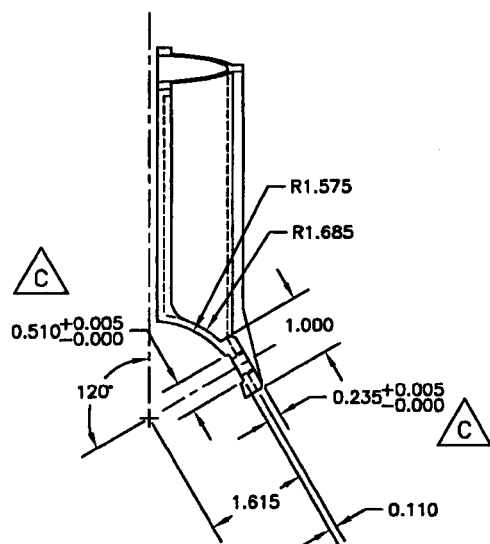
Measured by:	SD
Date:	06.09.23

Audited by:	En
Date:	06/09/26

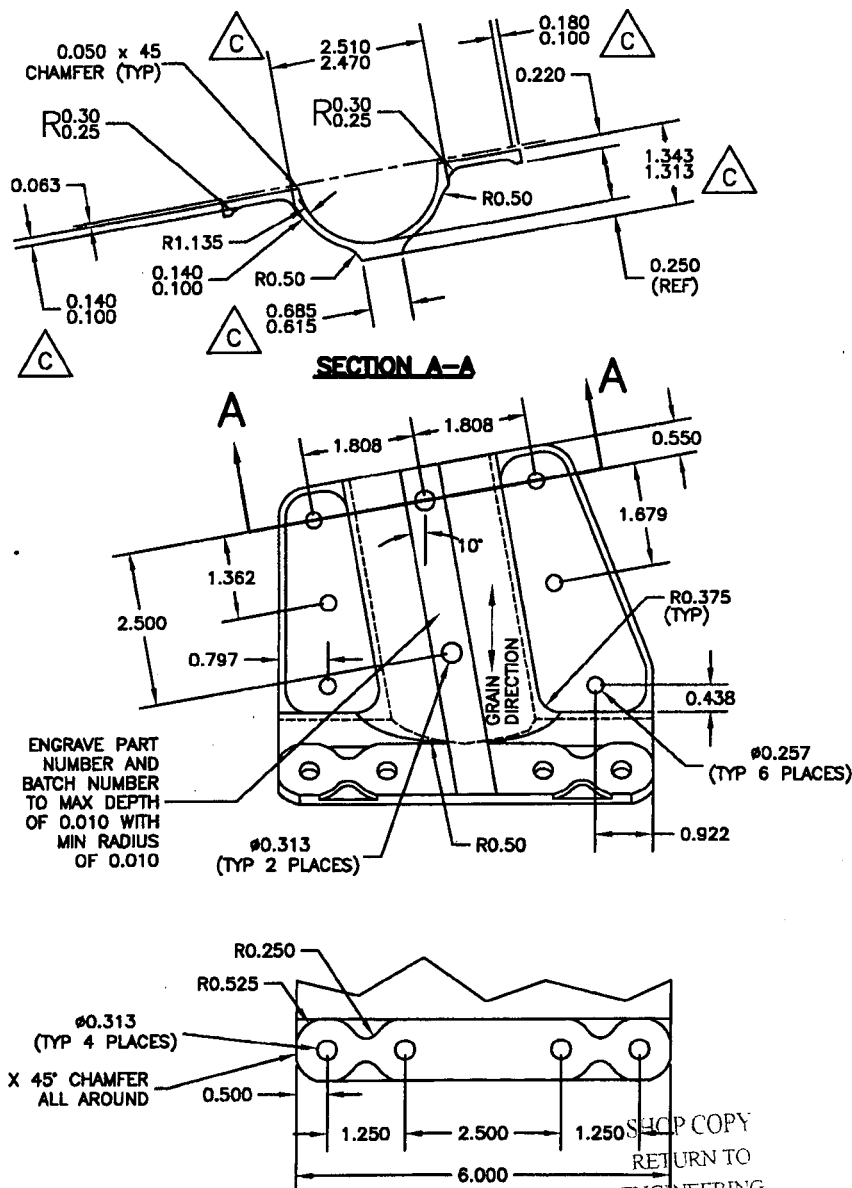
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

DART**RELEASED**
de de 24 H

DESIGN #	DRAWN BY C B	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D2666	REV. C SHEET 1 OF 1
DATE Q6.05.26	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	

**D2666-1 SADDLE FWD INSIDE HIGH****NOTES:**

- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



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